



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2665-1

Job Sheet 177467



Part No: D2665-1

Job Qty: 1 ea

Part Name: Saddle, LH Fwd Aft Out



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/14/18

Job Tracking No:

Due Date: 5/19/18

Created By: Jason Leroux

Type: Stock

Description:

Note: DWG REV D IPP: C 00.11.01 Removed P/O for Powder Coat - in house process EC IPP Rev:D As per Rev D 07-03-19 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard	Workcenter/Supplier	Sign-off
					Setup hrs	Run Hrs	
90	Start up Operation	1 Ea	5/19/18	5/19/18	0.00	0.00	Start Up Machining-1
100	CNC Vertical Machining	1 pcs	5/19/18	5/19/18	1.75	1.54	HAAS1-2
110	Mill Conv	1 pcs	5/19/18	5/19/18	0.00	1.00	Mill Conv 1
120	QC	1 pcs	5/19/18	5/19/18	0.00	0.00	QC2 Machining-1
130	QC	1 pcs	5/19/18	5/19/18	0.00	0.00	QC8 Machining-1
140	HandFinish	1 pcs	5/19/18	5/19/18	0.00	0.07	HandFinish1
150	Powdercoat	1 pcs	5/19/18	5/19/18	0.00	0.05	Powdercoat1
160	QC	1 pcs	5/19/18	5/19/18	0.00	0.00	QC3
170	Packaging	1 pcs	5/19/18	5/19/18	0.00	0.00	Packaging3-1
180	QC21-SA	1 Ea	5/19/18	5/19/18	0.00	0.00	QC21

Part Op 100 - Program batch number. 1- Inspect part number and batch number are programmed correctly. 2- Machine Step No 1 Descriptions: of Folio and visually inspect as per attached Dimension Sheet 3- Machine Step No 2 of Folio and visually inspect as per attached Dimension Sheet

110 - Machine Keyway and inspect per attached dimension sheet

150 - START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6101-003	Saddle Billet, 7075	1 Ea (1 ea)	90-Start up Operation	

5054514 → 5070964

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6101-003	1	96	0

Part Specifications

Specifications could not be found.

Plex 5/14/18 8:34 AM dart.leroux.jason



Container No: S070969



Part: D2665-1

Job No: 177467

Serial No/Batch: S070969

Revision:

Inspector:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 05/14/18

QC 4932

DQA: _____ Date: 18/06/11**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: <u>177 467</u>	DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS					
Part No. <u>026651</u>		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐		
NCR No.		Machining ☒	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐		
		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐		
		Large Fab ☐	Composite ☐	Supplier ☐			

Date : <u>18.06.11</u>	Step #: <u>100</u>	QTY Effective : <u>2</u>	MRB (QSI042) Approval <u>PD 18-06-11</u>
------------------------	--------------------	--------------------------	---

Description Work Order Deviation - Operator forgot to move .100" while taking x origin. - Skid tube holes are all .100" off tol.	Disposition Scrap and destroy.	Completed By <u>SBZ-01</u> Lead hand / Supervisor Approval Verification <u>18-06-11</u> QC / QA Coordinator Approval <u>PD 18-06-11</u>
---	--	--

Root Cause Environment ☐ No Re-verification ☐ Design ☒ Operator ☐ Doc/Data ☐ Offset/Setup ☐ Equip/Tooling ☐ Supplier ☐ Handling/Pre ☐ Training ☐ Material ☐ Use for Testing ☐ Internal Transport ☐ Poor Information ☐ Tribal Knowledge ☐ Rushing ☐ LOA ☐ Product Improvement ☐ Substation ☐ Process Improvement ☐ Past Expiry Date ☐ Manufacturing Process ☐ Misidentified ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Temperature/Cure ☐ Power Loss/Surge ☐ Positioned Wrong ☐ Bending ☐ Set-up ☐ Folio/Program ☐ Outside Dimensions ☐ Centre Not Concentric ☐ BOM/Route ☐ Grain ☒ Over/Under tolerance ☐ Cracks ☐ Broken/Damage/Defect ☐ Weld ☐ Part Incorrect ☐ Crimp/Kink/Ripple/Wave ☐ Inspection Incomplete/Unqualified ☐ Wrong Stock Pulled ☐ Part Lost/Missing ☐ Cuffs ☐ Contamination ☐ Out of Sequence ☐ Part Moved ☐ Crushing ☐ Countersink ☐ Off-set ☐ Drawing ☐ Heat Treat ☐ Cut Too Short ☐ Mislabeled ☐ Finish ☐ Wave/Twist in Tube ☐ Instructions Incomplete/Unclear ☐ Fit/Function ☐ Misread ☐ Marks/Chatter ☐ Drill Holes ☐ Misaligned/off center ☐ Turning Sequence ☐	
OTHER : _____			